

Date: Thursday, 20/11/2008 3:33:08 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ASPIRATOR INNER SHELL
Job Number : 43592	
Estimate Number : 11977	
P.O. Number :	Part Number : D2096
This Issue : 20/11/2008 S.O. No. :	Drawing Number : D2096 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A
Previous Run :	Material :
Written By :	Due Date : 25/12/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JWD 08.11.21</u>	
Comment : Est. B 99.01.20 Re-format DM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2060	Aspirator
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Aspirator

Pick:

Qty Part number Description Batch

1	D2060	Aspirator Core	B43586
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Sp 09/05/25 (20)

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

Drill 4 flange holes as per Dwg D2095/96 using Drill Jig DT 8262

Cut edges as per Dwg D2095 using Jig DT 8263

Mill 5/16 slot for jet as per Dwg D2095/96 using Milling Jig DT 8296

Deburr

Clean and polish with water and thinner

> m-h 09/06/03

SA 09/06/07 (19) PIC

m-h 09/06/09/ (14x)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

S 09/06/09 (15)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2096 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 09/06/05
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>43592</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/06/07</u>	<u>20</u>	<u>-Part moved while machining</u> <u>Re: process</u>	<u>[Signature]</u> <u>25/04/02</u>	<u>Sample destroyed</u> <u>no replace</u>	<u>SA</u> <u>09/06/07</u>	<u>SB</u> <u>09/06/03</u>	<u>[Signature]</u> <u>25/04/02</u>	<u>[Signature]</u> <u>09/06/08</u>

NOTE: Date & initial all entries

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Drawing Name: ASPIRATOR INNER SHELL

Job Number: 43592

Part Number: D2096

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

STH2

LC 9/6/5

(12)

5.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/09

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-06-09

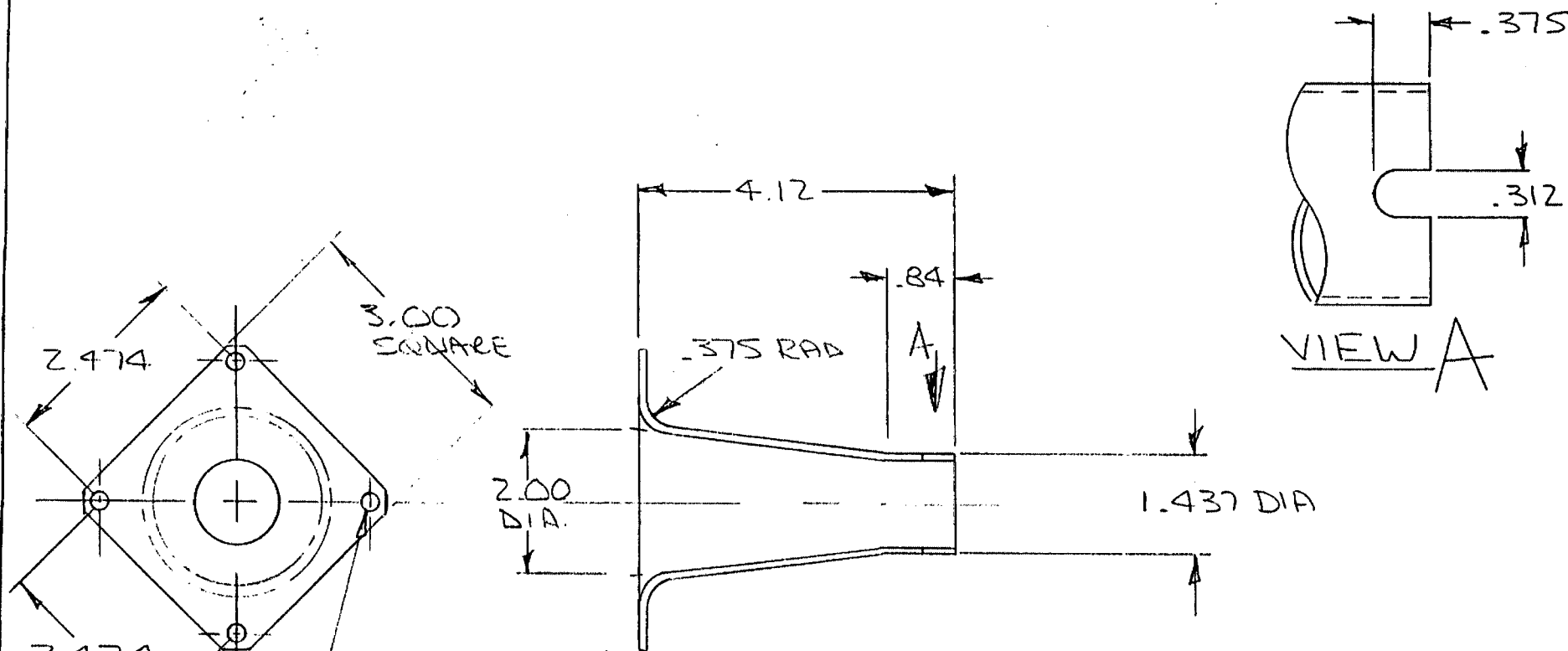
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DRILL $\frac{1}{4}$ (250) DIA
4 HOLES

D2095 SHOWN
D2096: VIEW 'A' SLOT
IS ROTATED 45°

MATERIAL: 1100-O-SPIN FROM
.062 SHEET

RELEASED
84/01/19
KANA

COPY ISSUED

REVISION 1 84/01/19 1/22 A 1/1 1/22 (52) 1/1		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO. CONTRACT NO.		ITEM DESCRIPTION		MATERIAL SPEC./VENDOR	
APPROVED 84/01/19		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER INCH — 8 — 32 5. HOLES PER AND 10287		LIMITS 1. TOLERANCES — .XX ± .030 .XX ± .010 2. ANGLES 1° 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL M/C CENTRE LINES .005		BASIC CODES D-DIMPLE DIGIT NO OF SHEETS C-COUNTERSINK LENGTH DASH NO W-SPOTWEALD 81-M520470AD 88-M520478AD		DRAWN DESIGNED STRIPS CHECKED CLIENT		DATE 12/1/1991	
DESCRIPTION OF CHANGE		REPORT ALL DISCREPANCIES — DO NOT SCALE		BASIC CODES		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		TITLE ASPIRATOR INNER SHELL		CODE D2095/96 SCALE 1:2 SH1 OF 1 REV A	